In the Claims:

1. (Amended) A progressive stamping die for forming a product from a work piece comprising:

a first die member;

a second die member;

an alignment mechanism for maintaining said first and second die members in axial alignment;

a pierce punch member in said first die member for punching an opening in a work piece positioned between said first and second die members;

at least one pilot member in said first die member for indexing a work piece positioned between said first and second die members;

a coin punch member in said first die member for forming a product from a work piece positioned between said first and second die member;

a biasing member in said second die member in axial alignment with said coin punch member; ~~and~~

a knockout punch member for removing a product from a work piece positioned between said first and second die member.; and

at least one sensor member in said second die member for determining whether an opening has been formed in a work piece or whether a product has been removed from a work piece.

2. (Original) A progressive stamping die for forming a product from a work piece in claim 1 wherein said biasing member comprises a gas spring member.

3. (Original) A progressive stamping die for forming a product from a work piece in claim 1 wherein said biasing member comprises a mechanical spring member.

4. (Original) A progressive stamping die for forming a product from a work piece in claim 1 further comprising an anvil member positioned adjacent said biasing member and in axial alignment with said coin punch member.

5. (Original) The progressive stamping die for forming a product from a work piece in claim 4 wherein said anvil member comprises a puck member, a bottoming disk member, a bottoming ring member, and a return pin member.

6. (Original) The progressive stamping die for forming a product from a work piece in claim 1 further comprising a scrap chute in said second die member at least in part in axial alignment with said pierce punch member.

7. (Amended) The progressive stamping die for forming a product from a work piece in claim 1 further comprising a product collection chute in said second ~~did~~ die member at least in part in axial alignment with said knockout punch member.

8. (Amended) A progressive stamping die for forming a plurality of products from a work piece comprising:

a first die member;

a second die member;

an alignment mechanism for maintaining said first and second die member in axial alignment; ~~and~~

at least two sets of punch members in said first die member with corresponding sets of biasing mechanisms and chute means in said second die member;

each of said sets of punch members comprising a pierce punch member, a coin punch member and a knockout punch member;

each of said sets of biasing mechanisms comprising a spring member positioned in axial alignment with one of said coin punch members~~.~~; and

at least one sensor member in said second die member for determining that a product is formed from a work piece.

9. (Original) The progressive stamping die for forming a plurality of products from a work piece in claim 8 wherein said spring member is a gas spring member.

10. (Original) The progressive stamping die for forming a plurality of products from a work piece in claim 8 wherein said spring member is a mechanical spring member.

11. (Original) The progressive stamping die for forming a plurality of products from a work piece in claim 8 wherein said biasing mechanism further comprises at least one anvil member.

12. (Original) The progressive stamping die for forming a plurality of products from a work piece in claim 11 wherein each of said anvil members comprises a puck member, a bottom disk member, a bottoming member, and a return pin member.

13. (Amended) The progressive stamping die for forming a plurality of products from a work piece in claim 8 wherein each of said chute ~~member~~ means comprises a scrap chute at least in part in axial alignment with said piece punch member and a product collection chute in axial alignment at least in part with said knockout punch member.

14. (Original) A method of forming a metal ring member from a work piece with a progressive stamping die, said method comprising the steps of:

positioning a work piece between a first stamping die member and a second stamping die member;

forming an opening in said work piece with pierce punch member;

indexing said work piece in said die member with at least one pilot member;

forming an annular ring member around the opening with a coin punch member, said annular ring member having a predetermined thickness and flat planar dimension by use of a biasing mechanism in axial alignment with said coin punch member; and

removing said formed annular ring member from said die with a knockout punch member.

15. (Original) The method of forming a metal ring member from a work piece with a progressive stamping die in claim 14 wherein said biasing mechanism comprises a gas spring mechanism.

16. (Original) The method of forming a metal ring member from a work piece with a progressive stamping die in claim 14 wherein said biasing mechanism comprises a mechanical spring member.

17. (New) A progressive stamping die for forming a product from a work piece as described in claim 1 wherein a pair of sensor members are provided for determining whether an opening has been formed in a work piece or whether a product has been removed from a work piece.

18. (New) A progressive stamping die for forming a product from a work piece as described in claim 1 wherein at least one sensor member is provided for determining whether an opening has been found in a work piece and at least one sensor is provided for determining whether a product has been removed from a work piece.

19. (New) A progressive stamping die for forming a product from a work piece comprising:

a first die member;

a second die member;

an alignment mechanism for maintaining said first and second die members in axial alignment;

a pierce punch member in said first die member for punching an opening in a work piece positioned between said first and second die members;

at least one pilot member in said first die member for indexing a work piece positioned between said first and second die members;

a coin punch member in said first die member for forming a product from a work piece positioned between said first and second die member;

a biasing member in said second die member in axial alignment with said coin punch member;

an anvil member positioned adjacent said biasing member and in axial alignment with said coin punch member, said anvil member comprises a puck member, a bottoming disk member, a bottoming ring member, and a return pin member; and

a knockout punch member for removing a product from a work piece positioned between said first and second die member.

20. (New) A progressive stamping die for forming a product from a work piece in claim 19 wherein said biasing member comprises a gas spring member.

21. (New) A progressive stamping die for forming a product from a work piece in claim 19 wherein said biasing member comprises a mechanical spring member.

22. (New) The progressive stamping die for forming a product from a work piece in claim 19 further comprising a scrap chute in said second die member at least in part in axial alignment with said pierce punch member.

23. (New) The progressive stamping die for forming a product from a work piece in claim 19 further comprising a product collection chute in said second did member at least in part in axial alignment with said knockout punch member.

24. (New) A progressive stamping die for forming a product from a work piece comprising:

a first die member;

a second die member;

an alignment mechanism for maintaining said first and second die members in axial alignment;

a pierce punch member in said first die member for punching an opening in a work piece positioned between said first and second die members;

a scrap chute in said second die member at least in part in axial alignment with said pierce punch member;

at least one pilot member in said first die member for indexing a work piece positioned between said first and second die members;

a coin punch member in said first die member for forming a product from a work piece positioned between said first and second die member;

a biasing member in said second die member in axial alignment with said coin punch member; and

a knockout punch member for removing a product from a work piece positioned between said first and second die member.

25. (New) A progressive stamping die for forming a product from a work piece in claim 24 wherein said biasing member comprises a gas spring member.

26. (New) A progressive stamping die for forming a product from a work piece in claim 24 wherein said biasing member comprises a mechanical spring member.

27. (New) A progressive stamping die for forming a product from a work piece in claim 24 further comprising an anvil member positioned adjacent said biasing member and in axial alignment with said coin punch member.

28. (New) The progressive stamping die for forming a product from a work piece in claim 27 wherein said anvil member comprises a puck member, a bottoming disk member, a bottoming ring member, and a return pin member.

29. (New) The progressive stamping die for forming a product from a work piece in claim 24 further comprising a product collection chute in said second did member at least in part in axial alignment with said knockout punch member.

30. (New) A progressive stamping die for forming a plurality of products from a work piece comprising:

a first die member;

a second die member;

an alignment mechanism for maintaining said first and second die member in axial alignment; and

at least two sets of punch members in said first die member with corresponding sets of biasing mechanisms and chute means in said second die member;

each of said sets of punch members comprising a pierce punch member, a coin punch member and a knockout punch member;

each of said sets of biasing mechanisms comprising a spring member positioned in axial alignment with one of said coin punch members and at least one anvil member, each of said anvil members comprising a puck member, a bottom disk member, a bottoming member, and a return pin member.

31. (New) The progressive stamping die for forming a plurality of products from a work piece in claim 30 wherein said spring member is a gas spring member.

32. (New) The progressive stamping die for forming a plurality of products from a work piece in claim 30 wherein said spring member is a mechanical spring member.

33. (New) The progressive stamping die for forming a plurality of products from a work piece in claim 30 wherein each of said chute means comprises a scrap chute at least in part in axial alignment with said piece punch member and a product collection chute in axial alignment at least in part with said knockout punch member.

34. (New) The progressive stamping die for forming a plurality of products from a work piece in claim 30 further comprising at least one sensor member in said second die member for determining whether a product has been formed from a work piece.

35. (New) A progressive stamping die for forming a plurality of products from a work piece comprising:

a first die member;

a second die member;

an alignment mechanism for maintaining said first and second die member in axial alignment;

at least two sets of punch members in said first die member with corresponding sets of biasing mechanisms and chute means in said second die member;

each of said sets of punch members comprising a pierce punch member, a coin punch member and a knockout punch member;

each of said sets of biasing mechanisms comprising a spring member positioned in axial alignment with one of said coin punch members; and

each of said chute means comprising a scrap chute at least in part in axial alignment with said piece punch member and a product collection chute in axial alignment at least in part with said knockout punch member.

36. (New) The progressive stamping die for forming a plurality of products from a work piece in claim 35 wherein said spring member is a gas spring member.

37. (New) The progressive stamping die for forming a plurality of products from a work piece in claim 35 wherein said spring member is a mechanical spring member.

38. (New) The progressive stamping die for forming a plurality of products from a work piece in claim 35 wherein said biasing mechanism further comprises at least one anvil member.

39. (New) The progressive stamping die for forming a plurality of products from a work piece in claim 38 wherein each of said anvil members comprises a puck member, a bottom disk member, a bottoming member, and a return pin member.

40. (New) The progressive stamping die for forming a plurality of products from a work piece in claim 35 further comprising at least one sensor member in said second die member for determining whether a product has been formed from a work piece.